

Date: Tuesday, 3/11/2008 7:57:13 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : CONSOLE TRIM ANGLE
Job Number : 37740	
Estimate Number : 10228	
P.O. Number :	Part Number : D2163
This Issue : 3/11/2008 S.O. No. :	Drawing Number : D2163 REV. B
Prsht Rev. : NC	Project Number : N/A
First Issue : 1 / Type : SMALL /MED FAB	Drawing Revision : B
Previous Run : 35583	Material :
Written By :	Due Date : 4/15/2008 Qty: 40 Um: Each
Checked & Approved By : <u>08 03 11</u>	
Comment : Est:F 02-05-11 Clarify IPP NG	
Est Rev:G 07-11-08 Now On Waterjet JLM Verified By:EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M5052H32S050	5052-H32 .050 Sheet
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Comment: Qty.: 0.0729 sf(s)/Unit Total : 2.9148 sf(s)

Material: 5052-H32 (QQ-A-250/8) 0.050" thick

(M5052H32S.050)

Batch: 14050IB 8-3-24

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D2163

Dwg Rev: BProg Rev: BIB 8-3-24

2-Deburr if necessary

IB 8-3-24

(SI)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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IB 8-3-24

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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08 03 24 (SI)
counted

Comment: SECOND CHECK

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE

Form as per QSI 003 and Dwg D2163

IB 08/03/25

(SI)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 3/11/2008 7:57:13 AM
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Process Sheet

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Drawing Name: CONSOLE TRIM ANGLE

Job Number: 37740

Part Number: D2163

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

↓ 08/03/25 (51) counts

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

BK 08-03-26 (51)

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

BK 08-03-27 (51)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

FL 08/03/27 (51)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST18

AS 08/03/28 (51)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/04/03 (51)

Job Completion



mf

08-03-28

W

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

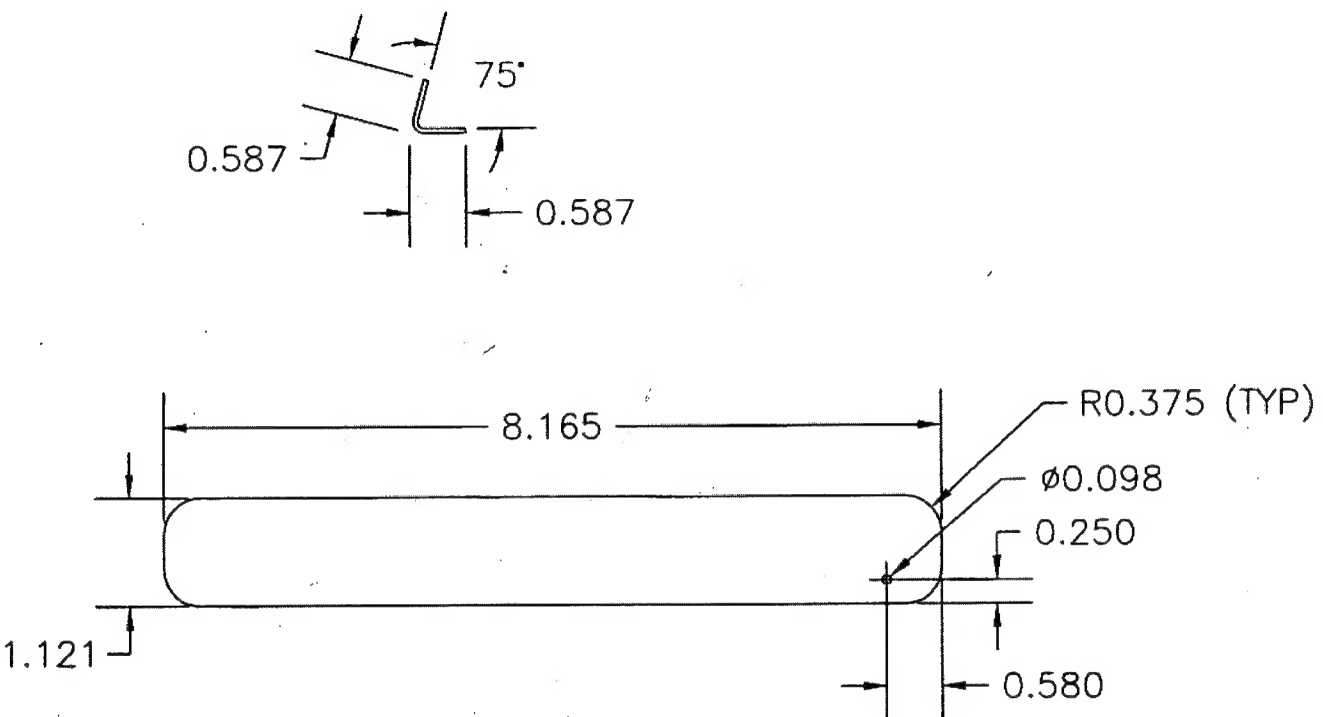
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	<i>[Signature]</i>	DRAWN BY	<i>Bw</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA
CHECKED	<i>KE</i>	APPROVED	<i>[Signature]</i>	DRAWING NO. D2163
DATE	97.10.30	TITLE	TRIM ANGLE	REV. B
		SCALE	1:2	SHEET 1 OF 1
A	95.05.19	RE-DRAWN		
B	97.10.30	REMOVE BEND DATA		

RELEASED
97.11.04 KE
TSR 4421



MATERIAL: 5052-H32 (QQ-A-250/8) 0.050 THICK
FINISH: POWER COAT MATTE BLACK PER DART QSI 005 4.3

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 37740